Work Order ID 52214 September 18, 2009 2:18:38 PM										Page 1
Revision ID: Here Name:	Bushing 3/09/2009 Start Qty: 750		Accept	Cust Item I Customer:			s	etup Star		
	Process Plan:QC:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Star Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr Rev B			<u> </u>						
100 Hardinge CNC Lathe	Hardinge CNC LAT Memo Small Machin	THE SMALL ne as per folio FA258□Del	0.00 0.00	rovar			751	Ø		
QC Quality Control	QC2- Inspect parts of Memo	off machine FAI/FAIB	0.00 0.00	107/26			451	6_		
QC	QC8- Inspect parts • Memo	- second check	0.00	9/04/30			751	þ		

Quality Control

Work Order ID 52214

Page 2

September 18, 2009 2:18:38 PM

Item ID:

D2570

Revision ID:

Bushing

В

Item Name: **Start Date:**

23/09/2009



Accept

Setup Start

Stop

Start Qty: 750.00 **Required Date: 30/09/2009** Req'd Qty: 750.00

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Draw

Number

Date:

Draw

Start

Stop

Reject Insp.

Sequence ID/ Work Center ID

130

Packaging

Operation Description

Identify as per dwg & Stock Location:_____

Memo

Set Up/ **Run Hours**

0.00

0.00

Code Rev.

Plan

Accept Qty

Reject Oty

Run

Number

Stamp

Packaging

140

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

09/10/01 A) M 09-10-1

Picklist Print

September 18, 2009 2:18:37 PM

Work Order ID: 52214

D2570RevB Parent Item:

Parent Item Name: Bushing



Start Date: 23/09/2009

Required Date: 30/09/2009

Page 1

Start Qty: 750.00

Required Qty: 750.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M303R0.750		Purchased	No			100	f	159.0451	60.8684			

303 Round Bar 0.750

Comments:

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	159.0451		
107077	0		
107857	18.49		
108220	10.69		
108877	14.41		
110166	10.16		
110680	9.29		
111323	7.9301		
112567	88.075		

60 Pt. Shorba/30

DART AEROSPACE LTD	Work Order:	52214
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	A Friot Attole Trototype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.800	+/-0.010	199					
0.060	+/-0.005	.058					
R0.010	+0.010/-0.000	R.015					
Ø0.425	+0.000/-0.002	0,424					
Ø0.257	+0.006/-0.001	0.258					
Ø0.750	+/-0.010	0.747					
0.030 x 20°	+/-0.010	.030x20°					
						.,.	
						- <u></u>	

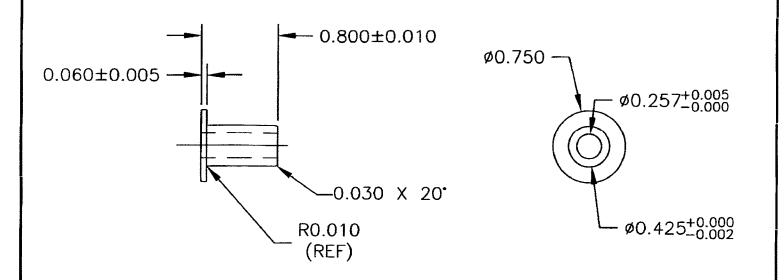
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 09/09/2	Date: 09/29/37	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM 1/A	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD 9	X
		<u> </u>	· · · · · · · · · · · · · · · · · · ·	



DESIG	N 1944	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. B
	林	H	D2570 SHEET 1 OF 1
DATE			TITLE SCALE
07.0	04.17		BUSHING 1:
Α		96.09.16	NEW ISSUE
В		07.04.17	UPDATE NOTES

RELEASED 101.06. 28 Th



D2570 BUSHING

D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX



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